



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

650.7010
Job Sheet 211056



Part No: 650.7010

Job Qty: 50 pcs

Part Name: Puncture Disc



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/2/20

Job Tracking No:

Due Date: 7/23/20

Created By: Patrick Lussier

Type: Stock

Description:

Note: 650.7000 REV.PNC1 IPP REV:A 20.06.18 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	50 pcs	7/23/20	7/23/20	0.00	0.00	Purchasing - 1 Purchasing - 2 Purchasing - 3	<i>[Signature]</i> AUG 06 2020
110	Packaging 2-1 - Receive - B4B	50 pcs	7/23/20	7/23/20	0.00	0.00	Packaging 2 - 1 - B4B Packaging 2 - 2 - B4B Packaging 2 - 3 - B4B Packaging 2 - 5 - B4B Packaging 2 - 4 - B4B Packaging 2 - 6 - B4B Packaging 2 - 7 - B4B Packaging 2 - 8 - B4B Packaging 2 - 9 - B4B Packaging 2 - 10 - B4B Packaging 2 - 11 - B4B Packaging 2 - 12 - B4B Packaging 2 - 13 - B4B Packaging 2 - 14 - B4B Packaging 2 - 15 - B4B Packaging 2 - 16 - B4B Packaging 2 - 17 - B4B Packaging 2 - 18 - B4B Packaging 2 - 19 - B4B Packaging 2 - 20 - B4B Packaging 2 - 21 - B4B Packaging 2 - 22 - B4B Packaging 2 - 23 - B4B Packaging 2 - 24 - B4B Packaging 2 - 25 - B4B Packaging 2 - 26 - B4B Packaging 2 - 27 - B4B Packaging 2 - 28 - B4B	<i>[Signature]</i> AUG 06 2020



Container No: S292408



Part: 650.7010

Job No: 211056

Serial No/Batch: S292408

Revision: REV.PNC1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/06/20

Plex 7/2/20 3:22 PM dart.lussier.patrick

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
120 QC 6	50 pcs	7/23/20	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	AUG 25 2020 DAS 40
					QC 6 - 81	9-89
					QC 6 - 82	
130 Packaging 3-1 - Stock - B4B	50 pcs	7/23/20	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS 28
					Packaging 3 - 6 - B4B	9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	AUG 26 2020
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
140 QC 21 - SA	50 pcs	7/23/20	0.00 0.00		QC 21 - SA - 21	DAS 21
					QC 21 - SA - 70	AUG 26 2020
					QC 21 - SA - 9	9-89
					QC 21 - SA - 77	

Part Op 100 - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** ISSUE P/O: POHB046674
 Descriptions: MANUFACTURE 650.7010 AS PER DWG C OF C IS REQUIRED
 110 - Receive & Inspect for Damage & Mat'l Certs

Patrick Lussier

Plex 7/2/20 3:22 PM dart.lussier.patrick

- 120 - QC6- All purchased or subcontracted products
130 - Identify as per dwg & Stock
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
650.7010P	Puncture Disc	50 Ea (1 ea)	100-Purchasing	S292407

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	650.7010P	50	0	0

Part Specifications

Specifications could not be found.

Plex 7/2/20 3:22 PM dart.lussier.patrick



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046674



Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046674
PO Date: 7/2/20
Due Date: 7/23/20
Purchase Order Revision:
Revision Date:
Issued By: Lussier, Patrick
Phone: 613-632-5200 Ext: 276
plussier@dartaero.com
Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	211056	650.7010P	650.7000 REV.PNC1	82 9-89		Puncture Disc	Firmed XSO	-	7/23/20	50 Ea	0 Ea	50 Ea	\$29.00/Ea	\$1,450.00
2	211057	650.7010P	650.7000 REV.PNC1			Puncture Disc	Firmed	-	1/21/21	50 Ea	0 Ea	50 Ea	\$29.00/Ea	\$1,450.00
Grand Total:													\$2,900.00	

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/6/20 11:50 AM dart.charest.martin

Packing Slip 39994



WEJAY MACHINE PRODUCTS COMPANY LIMITED

800 O'CONNOR DRIVE

KINGSTON, ON, CANADA K7P 1N3

TEL: 613-384-1662 FAX: 613-384-2997

WEJAY.COM

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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K

INVOICE DATE		YOUR ORDER NO. POHB046674		DATE ORDERED 07/06/20		SHIPPED VIA Best way	
CUSTOMER CODE DART		PROV. LIC. NO.		Extra ☐ Exempt ☐		TERMS	
QUANTITY ORDERED 50	B.O. 0	QUANTITY SHIPPED 50	DESCRIPTION Puncture disk as per drawing 650-7000 Rev. PNC1 Part number: 650.7010P Job number: 211056 Required by: July 23, 2020 1-Box Fedex: 7711-8508-0413 RELEASE NOTE I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order. Inspection Supervisor  			UNIT PRICE	AMOUNT

RECEIVED
AUG 06 2020
DART AEROSPACE LTD.

ORDER: COMPLETE ☐
PARTIAL ☐

TOTAL

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF CONFORMANCE

CUSTOMER: DART Aerospace Ltd.

DATE: Aug. 5, 2020

P.O.# POHB046674

WEJAY JOB# 39994/ 39995

I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.

PO LINE	PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
1	650.7010P "Puncture Disc" Job: 211056	50	Machined complete per drawing req'ts.	650.7000 / Rev. PNC1
2	650.7010P "Puncture Disc" Job: 211057	50	Machined complete per drawing req'ts.	650.7000 / Rev. PNC1

Note: 1) Material Test Cert. attached - ref. "ZAPP Precision Strip Inc. Heat# M55N6BG (Wejay TN# 35735-1).
2) 1st Article Inspection Reports attached.

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

DAS
82
9-89

Clifford Smith
Authorized Q.A. Signatory

Zapp Precision Strip, Inc. 12633 Clark Street, Santa Fe Springs, CA 90670

ACCUTREX PRODUCTS INC.
LAMINATED MATERIALS DIVISION
112 SOUTHPOINTE BOULEVARD
CANONSBURG PA 15317

Zapp Precision Strip, Inc.
12633 Clark Street
Santa Fe Springs, California
90670
Phone+1 562-944-5484
Fax+1 562-944-1874
Tollfree 888-236-0004
www.zapp.com

Member of the Zapp Group

March 22, 2011

Inspection certificate Type 3.1 per EN 10204:2004

Certificate No. 2210026349000010 01

Your purchase Order M13801 dated 03/09/2011

Sales Order 2302015754 Delivery Note 2210026349

Production Lot 2256045 Inspection Lot 020000186713

Item 10 NICKEL AND NICKEL ALLOYS

Grade / Alloy Ni 400

Dimensions 0.0025 " X 12.0000 "

Thickness tolerance -0.00013 " / 0.00013 "

Width tolerance 0.00000 " / 0.50000 "

Conditions Annealed

Surface Bright Annealed Finish

Techn. Specification ASTM B127-05

Techn. Specification ASME SB127 EDITION 2010

Techn. Specification AMS 4544 REV. F

Material 8700028

Quantity / Weight 10.000 LB

DAS
82
9-89

Chemical composition

Heat M55N6BG

Ni (%)	Co (%)	Fe (%)	Mn (%)	Al (%)	C (%)
63.840✓	0.020 ✓	2.140	0.920 ✓	0.0400	0.090 ✓
Cu (%)	Si (%)	S (%)	Ti (%)	P (%)	
32.720✓	0.170 ✓	0.0010 ✓	0.0500	0.0090	
Melt Source Special Metals - US					

Quality inspection results

Tensile Strength	74.9 KSI
.2% Yield Strength	31.2 KSI
Elongation 2"	35.50 %
Grain Size	9.0
Hardness	61.0 HRB

Batch D007371074

Sizes and Quality identification test examined and in order.

MAR 23 2011
156130-m PH

Recd AUG 5/20
JOB#39994/39995
TN 35735-1

WMP
03

ZAPP

Zapp Precision Strip, Inc. 12633 Clark Street, Santa Fe Springs, CA 90670

ACCUTREX PRODUCTS INC.
LAMINATED MATERIALS DIVISION
112 SOUTHPONTE BOULEVARD
CANONSBURG PA 15317

Zapp Precision Strip, Inc.
12633 Clark Street
Santa Fe Springs, California
90670
Phone +1 562-944-5484
Fax +1 562-944-1874
Tollfree 888-236-0004
www.zapp.com

Member of the Zapp Group

Contact: Beatriz Campos
Phone +1 562-944-5484-10 Fax +1 562-944-1874 , Beatriz.Campos@zapp.com

March 22, 2011

Packing list 2210026349

Order 2302015754
Consignee 632337
Your order: M13801 from 03/09/2011

Item 010 NICKEL AND NICKEL ALLOYS
Grade / Alloy Ni 400
Dimensions 0.0025 " X 12.0000 "
Thickness tolerance -0.00013 " / 0.00013 "
Width tolerance 0.00000 " / 0.50000 "
Conditions Annealed
Surface Bright Annealed Finish
Tensile 70.0 ksi - 85.0 ksi
Coil Inner Diameter 6.0000 "
Coil Weight 10 lb - 10 lb
Techn. Specification ASTM B127-05
Techn. Specification ASME SB127 EDITION 2010
Techn. Specification AMS 4544 REV. F
Material 8700028

Ident.	Packing	No.	Net	Gross
D007371074		1	10 LB	148 LB
Total	packages	1	10 LB	148 LB

MAR 23 2011
156130-M 83

REC'D AUG. 5/20
JOB #39994/39995
TN35735-1

Zapp Precision Strip, Inc. 12833 Clark Street, Santa Fe Springs, CA 90670

**ACCUTREX PRODUCTS INC.
LAMINATED MATERIALS DIVISION
112 SOUTHPOINTE BOULEVARD
CANONSBURG PA 15317**

March 22, 2011

Surface visual inspection at finish: without objection

In compliance with the conditions mentioned in the acknowledgement of order.

This certificate signifies that the material meets the appropriate requirements defined in the current revision of the following specifications: ISO 9445-1; ISO 9445-2; ASTM A480/A480M; DIN EN 10140. This document may not be reproduced except in its entirety.

This certificate has been issued by computer and is valid without signature.

ZPS / GENE SHELDON (MANAGER TECHNICAL SERVICES) +1 508-998-6300

ZAPP Precision Strip does not use mercury in the testing or production of material.

ZAPP Precision Strip is certified to ISO 9001, AS 9100 and is approved as a manufacturer according to AD2000-MERKBLATT W0 and the Pressure Equipment Directive PED 97/23/EC. To view certificates go to customer information www.zapp.com

MAR 23 2011
156130-m RB



AccuTrex Products, Inc.

112 Southpointe Blvd.

Canonsburg, PA 15317-9559

Phone: (724) 746-4300 Fax: (724) 746-0711

Certificate of Conformance

Date: 07/31/20

WEJAY MACHINE PRODUCTS
600 O'CONNOR DRIVE
KINGSTON
ONTARIO, K7P 1N3
CANADA

Attention: Quality Assurance

PO# 0000035735

This is to certify that your purchase order for the following part(s) was made in accordance with your drawings and specifications. Mercury-bearing instruments and/or equipment which might cause contamination were not used in the manufacturing, fabrication, or assembly of any material furnished under the order. Parts were manufactured in the USA.

<u>Quantity</u>	<u>Part Number</u>	<u>REV</u>	<u>Lot Ctrl No (LCN)</u>	
100	335DISC	0	156130-M	

Sincerely,

Carl J. Sharp

Carl J. Sharp
Production Manager
Metal Shop

First Article Inspection Report

(Report all dimensions and features required by drawing)

Page 1 of 2

Customer : DART AEROSPACE LTD.

Customer P.O. No.: POHB046674 LINE ITEM 2 (JOB 211057)

Wejay Job No.: 39995

Part Description: PUNCTURE DISC

Part No.: 650.7010P

Manufacturing Production Order Operation No.: 50

Drawing Number (Including Revision): 650.7000 REV. PNC1

Drawing Balloon Item (When attaching drawing to itemize features)	Dimension Required	Actual Dimension recorded
<u>1</u>	<u>$\varnothing.335 \pm .003$</u>	
<u>2</u>	<u>$.0025 \pm .00025$</u>	
<u>3</u>	<u>$32 \checkmark (2 \text{ Pls.})$</u>	

Equipment Used: WM087, WM021, WM183

☒ Accepted ☐ Not Accepted NCR (If applicable) —

Reviewed by:

Production: _____

Date: _____

Quality Control: Clifford

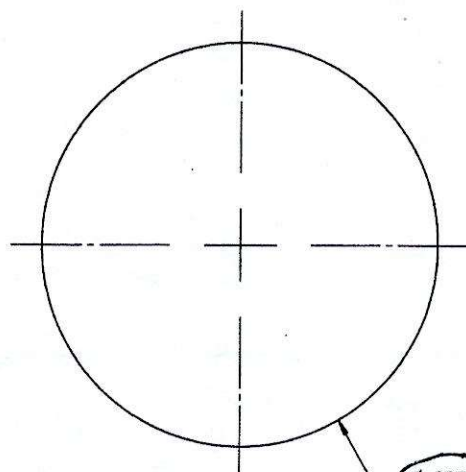
Date: AUG 5/20

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DBA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES DBA DART AEROSPACE IS PROHIBITED.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE	04-24-2014	P. BRAVO
	LAST PROTOTYPE RELEASE XX		T. CROSS

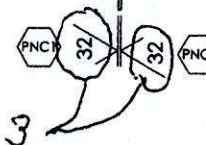
NOTES:

- 1 MATERIAL: MONEL 400 IAW AMS-4544
- 2 DEBURR AND BREAK ALL SHARP EDGES
- 3 IDENTIFY IAW MPP-120



Ø.335±.003

.00250±.00025



PROTOTYPE REVISIONS							
ZONE	REV	DESCRIPTION	DATE	APPROVED	CHANGE CODE	EFFECTIVITY	REVISED BY.
C6-1	PNC1	ADDED SURFACE ROUGHNESS VALUE	06/01/2020	T. CROSS	DC	NEXT ORDER	K. TAILOR

QTY	1	650.7010	PUNCTURE DISC		
PART NO.					
DESCRIPTION					
MATL					
SPEC					
PARTS LIST					
NEXT ASSY (S)					
ORIGINAL DATE 04-24-2014					
DRAWN BY J. CROSS					
N/CAP P. BRAVO					
DRAWING APPROVAL					
P. BRAVO					
04-24-2014					
CONTRACT NO.					
UNLESS OTHERWISE SPECIFIED					
DIMENSIONS ARE IN INCHES					
TOLERANCES ARE					
1 PLACE DECIMALS ±.01					
3 PLACE DECIMALS ±.005					
ANGLES ±.5°					
DART AEROSPACE 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300					
PUNCTURE DISC					
SIZE	CAGE CODE	DRWG. NO.			
8	07M426	650.7000			PNC1
SCALE NONE				SHEET 1 OF 1	

(Report all dimensions and features required by drawing)

Drawing Number (Including Revision): 650-7000 RAU, PNCL

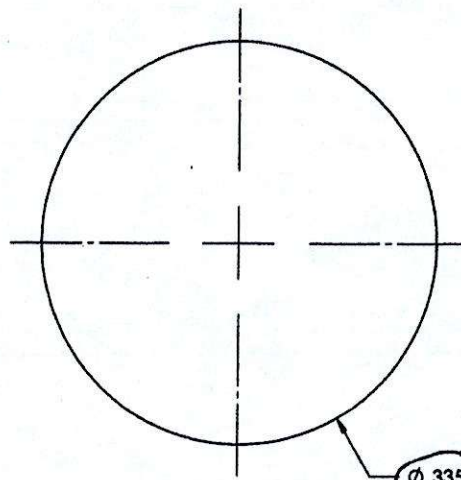
Form No WJM-05, Rev 1

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE	04-24-2014	P. BRAVO
	LAST PROTOTYPE RELEASE XX		T. CROSS

NOTES:

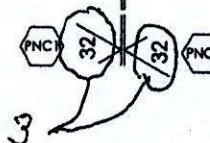
1. MATERIAL: MONEL 400 IAW AMS-4544
2. DEBURR AND BREAK ALL SHARP EDGES
3. IDENTIFY IAW MPP-120



Ø.335±.003

2

.00250±.00025



3

PROTOTYPE REVISIONS						
ZONE	REV	DESCRIPTION	DATE	APPROVED	CHANGE CODE	EFFECTIVITY
C6-1	PNC1	ADDED SURFACE ROUGHNESS VALUE	06/01/2020	T. CROSS	DC	NEXT ORDER

QTY	1	650.7010	PUNCTURE DISC	△	
REV	NO.	PART NO.	DESCRIPTION	MATL	SPEC
PARTS LIST					
NEXT ASSY (S)					
ORIGINAL DATE (DD-MN-YY)					
DRAWN BY: HCAP					
CHECKED BY: P. BRAVO					
DRAWING APPROVAL					
DATE: 04-24-2014					
CONTRACT NO.					
PUNCTURE DISC					
3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300					
DART AEROSPACE APICAL INDUSTRIES INC. DBA DART AEROSPACE					
PUNCTURE DISC 650.7000 SCALE: NONE SHEET 1 OF 1					